

DGL 1,250

Work Order ID 128432

128432

Page 1

Friday, January 16, 2015 2:37:05 PM

Item ID: D3417-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Washer

Start Date: 1/16/15

Start Qty: 20.00

20

Cust Item ID:

Required Date: 1/16/15

Req'd Qty: 20.00

20

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3417

Rev F

100

0.00

100

Doosan

DOOSAN LATHE

Memo

0.00

Doosan Lathe

1-Turn as per Folio FA594 Rev: 1/1 & Dwg D3417 Rev: F 2-Debur

41 0 DAS 25 9-89 15-1-22

110

0.00

110

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

41 0 DAS 25 9-89 15-1-22

120

0.00

120

QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

41 0 DAS 14 9-89 15-1-23

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 128432

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128432

Page 2

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Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Washer

Start Date: 1/16/15

Start Qty: 20.00

20

Cust Item ID:

Required Date: 1/16/15

Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: St038

0.00

130

Packaging

Memo

0.00

Packaging

41 ML5 15-01-26

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

15/1/28 df15-1-27

DQA: _____ Date: _____



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Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Friday, January 16, 2015 2:37:05 PM

Page 1

Work Order ID: 128432

128432

Parent Item: D3417-3

D3417-3

Parent Item Name: Washer

Start Date: 1/16/15

Required Date: 1/16/15

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A05.10.19New issueKJ/EC
IPP Rev:B05.10.19added haas op. EC
IPP Rev:C As per Rev D 08-07-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MDEL RINR1.2500

Purchased

No

100

f

10.0800

0.0296

1

MDFI RINR1 2500

SL 15-1-22

DEL RIN ROUND BAR 1.25" color: black

Location

Loc Qty

Loc Code

MAT039

10.08

m128113

10.08

1.9

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

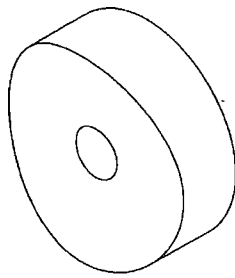
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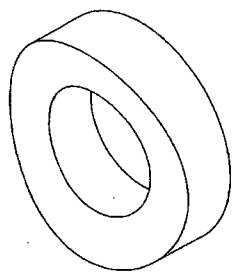
FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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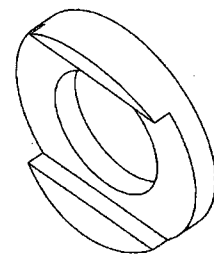
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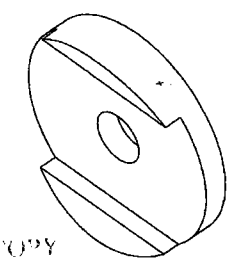
D3417-1 WASHER



D3417-3 WASHER

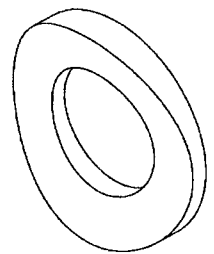


D3417-5 WASHER



D3417-7 WASHER

UNCONTROLLED COPY
 SPECIFICATION
 W/OUT
 WORK
 NO. 128432-ML5
 150119



D3417-9 WASHER

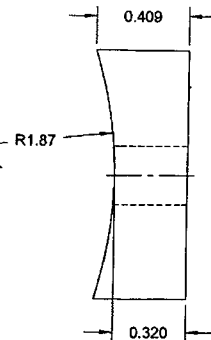
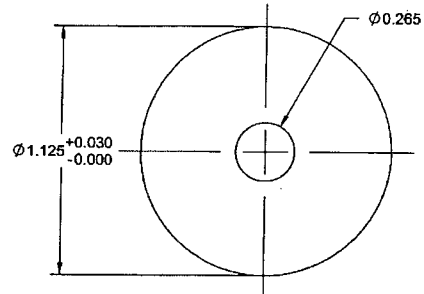
RELEASED
 2010-09-15

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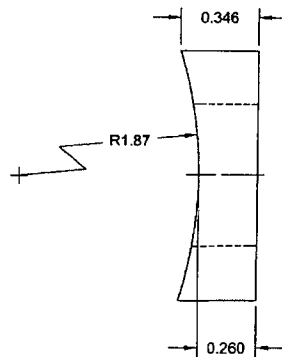
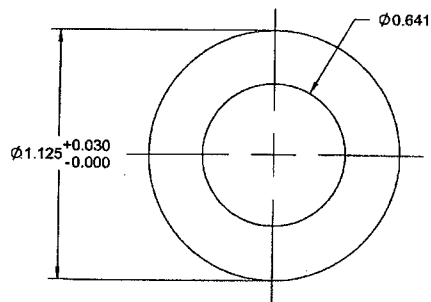
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 REF DART SPEC M-DELRIN-R
 OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, BAR
 REF DART SPEC M-DELRIN-B
 OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, SHEET
 REF DART SPEC M-DELRIN-S
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3417-1, 0.020 lbs
 D3417-3, 0.010 lbs
 D3417-5, 0.010 lbs
 D3417-7, 0.010 lbs
 D3417-9, 0.004 lbs

F	ADD D3417-9 (ZN B5-3)	SC	10.07.26
E	ADD D3417-7 (ZN A2-2)	RF	09.06.30
D	ADD -5 WASHER (ZN B2-1, B2-2); REFORMAT TO "B" SIZE & UPDATE TO CURRENT STANDARDS; REASON: INSTALLATION OF NEW TOW RING	AJS	08.07.08
C	REMOVE CBORE, WIDEN	PH	05.06.30
B	CHANGE TO ROUND WASHER	PH	05.06.10
A	NEW ISSUE	PH	05.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3417	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WASHER	NTS
DATE	10.07.26	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRELIMINARY AND CONSIDERATION SHOULD BE GIVEN TO THE FOLLOWING CONDITIONS: THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

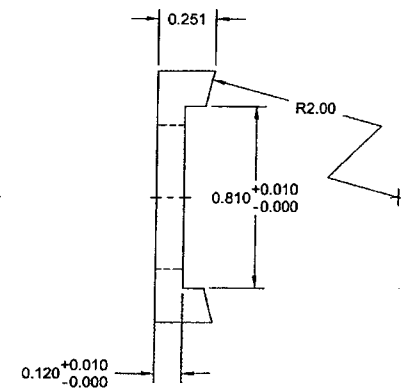
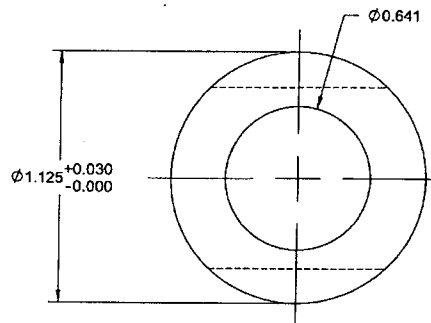
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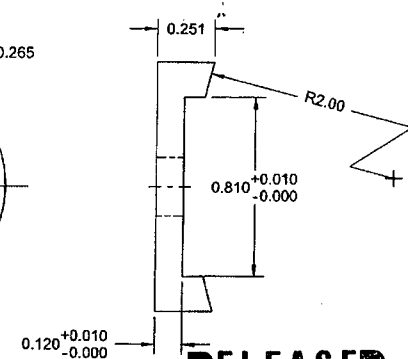
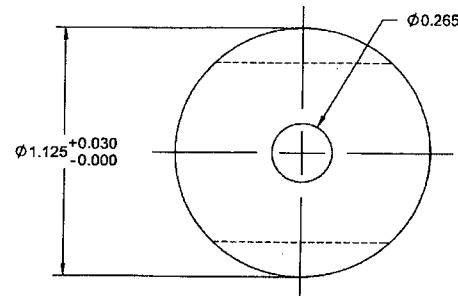
D3417-1 WASHER



D3417-3 WASHER



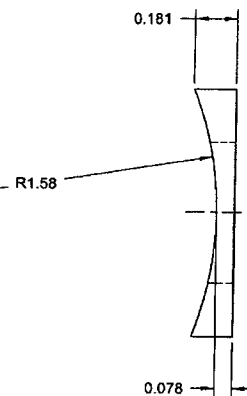
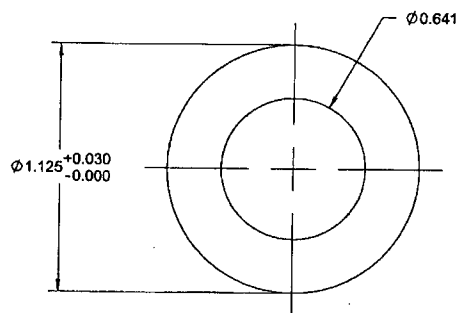
D3417-5 WASHER



D3417-7 WASHER

RELEASED
2010-09-15

DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3417	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WASHER	NTS
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D3417-9 WASHER



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DRAWN	SC		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3417	SHEET 3 OF 3
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